

17/09

Date: Tuesday, 9/11/2007 10:56:36 AM
User: Chantal Lavoie

Process Sheet

Customer : N/A	Drawing Name : COVER
Job Number : 34544	
Estimate Number : 12963	
P.O. Number : N/A	Part Number : D36414
This Issue : 9/11/2007	Drawing Number : D3641 UNDER REVIEW
S.O. No. : N/A	Project Number : N/A
Prsht Rev. : NC	Drawing Revision : U/R
First Issue : N/A	Material : N/A
Previous Run : N/A	Due Date : 9/18/2007
Written By : <u>V</u>	Qty: 12 Um: Each
Checked & Approved By : <u>V</u>	
Comment : Est Rev: A New Issue 07-07-20 JLM	Verified By: EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S032 6061-T6 Sheet 0.032"



Comment: Qty.: 0.8244 sf(s)/Unit Total: 9.8923 sf(s)

M6061-T6 .032" THK sheet

Batch: m16954 HB 07-09-12

POSITIVE
RECALL

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3641

Dwg Rev: A HB 07-09-12

Prog Rev: A

(B)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 07-09-12

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

EC 07/09/12 (B)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3641

EB 07/09/13

(PTO)

(B)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 07/10/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.09.12	5.0	120° ANGLE NOT ACHIEVED 2.50 IS 2.67	VE 07.09.12	ACCEPTABLE PART WILL FUNCTION IN SERVICE AS INTENDED. NOT A STRUCTURAL PART.	VE 07.09.12	En 07/10/12	VE 07.09.12 (251 042)	Jo 07/11/12

NOTE: Date & initial all entries

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Process Sheet

Customer:

Drawing Name: COVER

Job Number: 34544

Part Number: D36414

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 07/04/13 (+13)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR

07-09-14

(B)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Er 07/04/14 (+13)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: _____

7/10/15 SP

13x

ENGINEERING
APPROVAL

POSITIVE
RECALL

07.09.14
D 07/10/15

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 07/04/13 AUTH U

RELEASED LE DATE 07.10.15

U

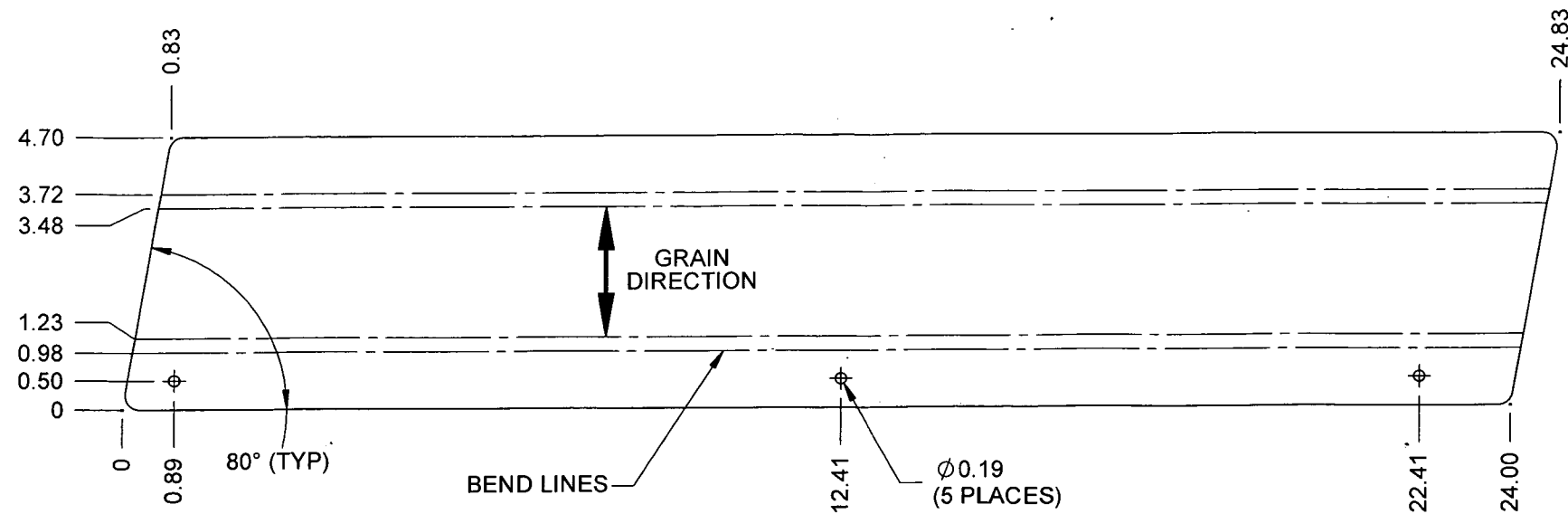
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

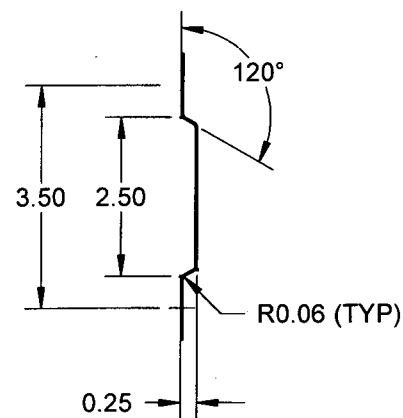
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3641-3F FLAT PATTERN



**D3641-3 COVER
(REPLACES GENEVA P/N G10606-5)
D3641-4 OPPOSITE
(REPLACES GENEVA P/N G10606-4)**

PRELIMINARY ISSUE

07.09.07 16

NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM 0.032 THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-3/-4" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.36 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	CE	PORT HADLOCK, WA	
CHECKED	JB	DRAWING NO.	REV. A
MFG. APPR.	EE	D3641	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.		COVER	1:3
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

Non-Conformance Report				NCR 08-112	
Raised by: <u>Jason Murdoch</u>		Source: <u>Q.C. Inspection</u>		Sheet No. <u> </u> of <u> </u>	
Non-Conforming Dept./Supplier: <u>Procl - Packaging stores</u>		Date: <u>08.11.12</u> 11.11.12		Priority: <u>HIGH</u> <u>LOW</u>	
Product/Service: <u>shoulder harness kit (D350-764-011) D3641-3 & -4</u>					
Area of Standard: QSI		Section A			
QSP		Description of Non-Conformance: <u>The -3 and -4 parts</u>			
QSPM		<u>were mixed up & not identified correctly. They</u>			
		<u>were stacked & identified as the opposite.</u>			
Documents:		<u>See also w/o D350-764-011 B 43227</u>			
P/O					
Invoice					
W/O					
Batch No. <u>34543 & 34544</u>		REFERENCE ONLY			
TSR		Root Cause: <u>The drawing was not verified when identifying the</u>			
Drawing <u>D3641</u>		<u>parts for stock. Lack of Attention.</u>			
Forward to Director, Quality Assurance on completion of Section A					
DQA: Section B: Indicate who is responsible for creating C/A, and a completion date. Section C: Indicate who will verify completion of C/A.					
Section B		Responsible for Investigation/CA: <u>L. Lucelle</u> To be done by: <u>08.11.20</u>			
Corrective Action					
No	Initial	Action Description	Responsible	Due date	Sign/Date
1	J.M.	<u>Determine affected kits & none in stock</u>	L. Lucelle	06.11.12	<u>06.11.12</u>
2	J.M.	<u>Quarantine all stock. Note: 1x D3641-3 was found</u>	J.M.	06.11.12	<u>06.11.12</u>
		<u>changed in w/o above.</u>			
3	J.M.	<u>Re-identify stock: Qty 1 -4 B34544 → now</u>	J.M.	06.11.12	<u>06.11.12</u>
		<u>-3 B 34543</u>			
4	J.M.	<u>Ensure all Employees are aware to verify the</u>	J.M.	08.11.12	<u>08.11.12</u>
		<u>drawing in relation to the part when identifying,</u>			
		<u>and to ask questions if they are uncertain</u>			
		<u>of the views on the drawing. Re-train the</u>			
		<u>employees on how to interpret the drawing, and</u>			
		<u>views.</u>			
5	J.M.	<u>Attach a copy of the NCR to the original copy of</u>	J.M.	08.11.20	<u>08.11.20</u>
		<u>all the affected w/o's.</u>			
Preventive Action Required: <input checked="" type="radio"/> NO YES # <u> </u>				Fault Category: <u>Procl - Stores packaging</u>	
Section C		Responsible for Verification of CA: <u>S. Sheld</u>			
Verification of C/A					
No	Verification Method		Sign	Date	
1					Forward to DQA on
2	<u>Discussed w/ NCR Review</u>		<u>[Signature]</u>	08.11.20	Completion of Verification
3					DQA: <u> </u>
4	<u>System in place to prevent</u>				Date: <u> </u>
5	<u>recurrence.</u>				
QA Purposes only			N/C Closed		Date <u> </u>